

# Work Order ID 83391

Wednesday, April 18, 2012 8:28:33 AM

ASAP

\*83391\*

Page 1

Item ID: D3536-25 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Gasket  
 Start Date: 4/17/2012 Start Qty: 20.00 \*20\* Cust Item ID:  
 Required Date: 4/30/2012 Req'd Qty: 20.00 \*20\* Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/04/10 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
 Run Start \*NR1\*  
 Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3536	Rev A

100

0.00

\*100\*

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg D3536 Dwg Rev: A Prog Rev: A 2-  
 Deburr if necessary

0.00

110

\*110\*

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

120

\*120\*

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

8/7/12

cuts  
 126

B12-4-2

B12-4-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 83391**

Wednesday, April 18, 2012 8:28:33 AM

**\*83391\***

Page 2

Item ID: D3536-25

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Gasket

Start Date: 4/17/2012 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 4/30/2012 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Run Start

**\*NR1\***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

**\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg & Stock Location: **FP**

0.00

**\*130\***

Packaging

Memo

0.00

Packaging

**26x****SP****12-04-27**

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

**12/4/30****12-04-27**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, April 18, 2012 8:28:37 AM

Work Order ID: 83391

\*83391\*

Parent Item: D3536-25

\*D3536-25\*

Parent Item Name: Gasket

Start Date: 4/17/2012

Required Date: 4/30/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	599.7520	0.5956	13.23556	15.5		

\*MNEO60S 063\*  
NEOPRENE SHEET 0.063

\*\*

B12-4-2  
(X)

Location

Loc Qty

Loc Code

MAT052

599.752

120948

599.752

120948

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	<b>83391</b>
<b>Description:</b> Gasket		<b>Part Number:</b>	<b>D3536-25</b>
<b>Inspection Dwg:</b> D3536 <b>Rev:</b> A		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
21.80	+/-0.030	21.86	L		T B02	
16.35	+/-0.030	16.35	✓		T	
10.90	+/-0.030	10.96	L		T	
5.45	+/-0.030	5.45	✓		✓	
6.00	+/-0.030	6.00	L		T	
6.75	+/-0.030	6.75	✓		T	
12.75	+/-0.030	12.75	✓		T	
1.89	+/-0.030	1.885	2		V B01	
0.30	+/-0.030	0.320	>		V	
0.30	+/-0.030	0.304	2		V	
Ø0.19	+0.005/-0.001	-0.193	2		V	

<b>Measured by:</b> B	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 12-4-26	<b>Date:</b> 12/4/77	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.06.13	New Issue	KJ/JLM	E

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

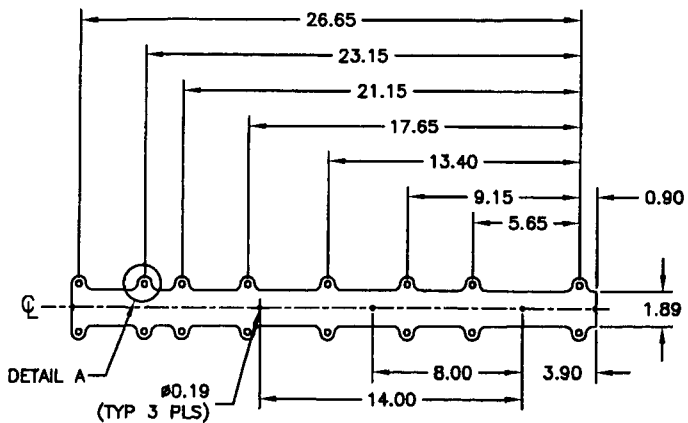
NOTE: Date & initial all entries



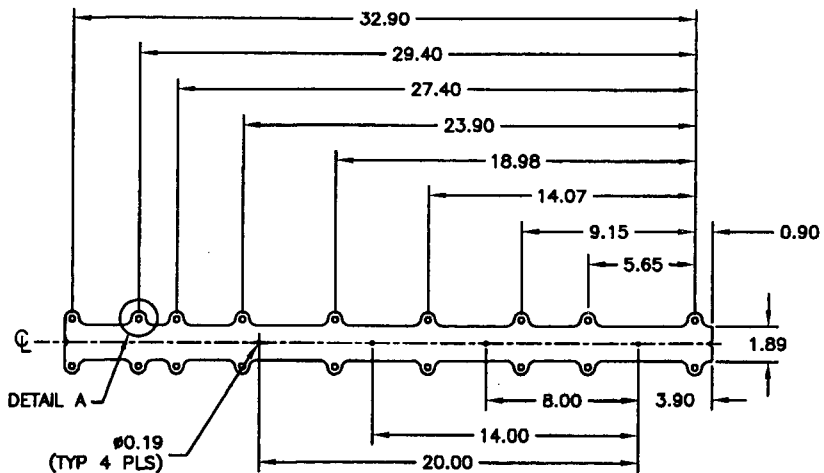
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RELEASED  
04.02.12

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 83391 MLJ  
12/04/10




**D3536-11 GASKET**



**D3536-13 GASKET**

**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 80 DUROMETER (REF DART SPEC. M-NEO80-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

DESIGN		DRAWN BY	DART AEROSPACE USA, INC.	
CB		CB	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. A	
AH		D3536	SHEET 1 OF 6	
DATE	TITLE		SCALE	
06.10.25	GASKET		1:10	
A	06.10.25	NEW ISSUE		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

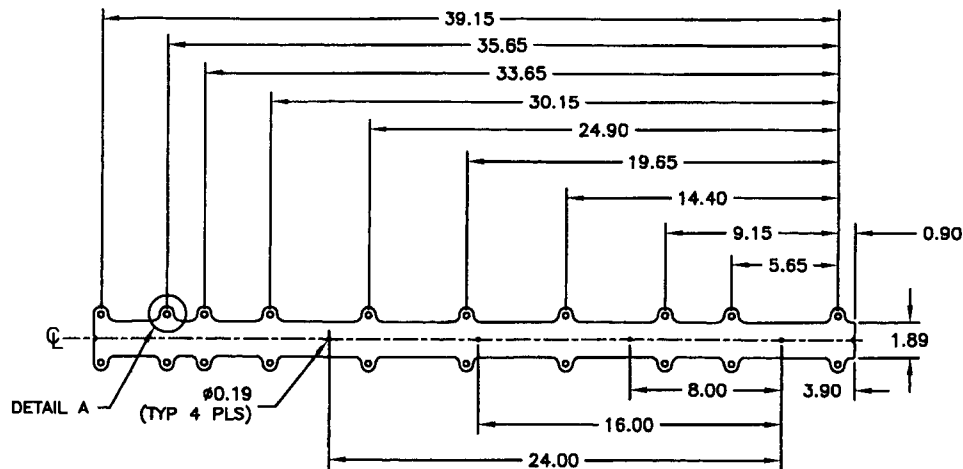
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

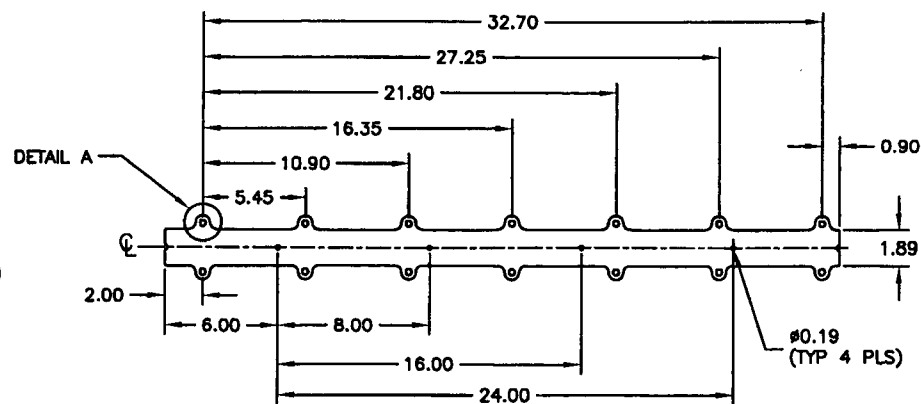
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CHECKED	AT	APPROVED		PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 2 OF 6
				SCALE
				1:10

03391  
070212  
REL 10/10/10



**D3536-15 GASKET**



**D3536-21 GASKET**

**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

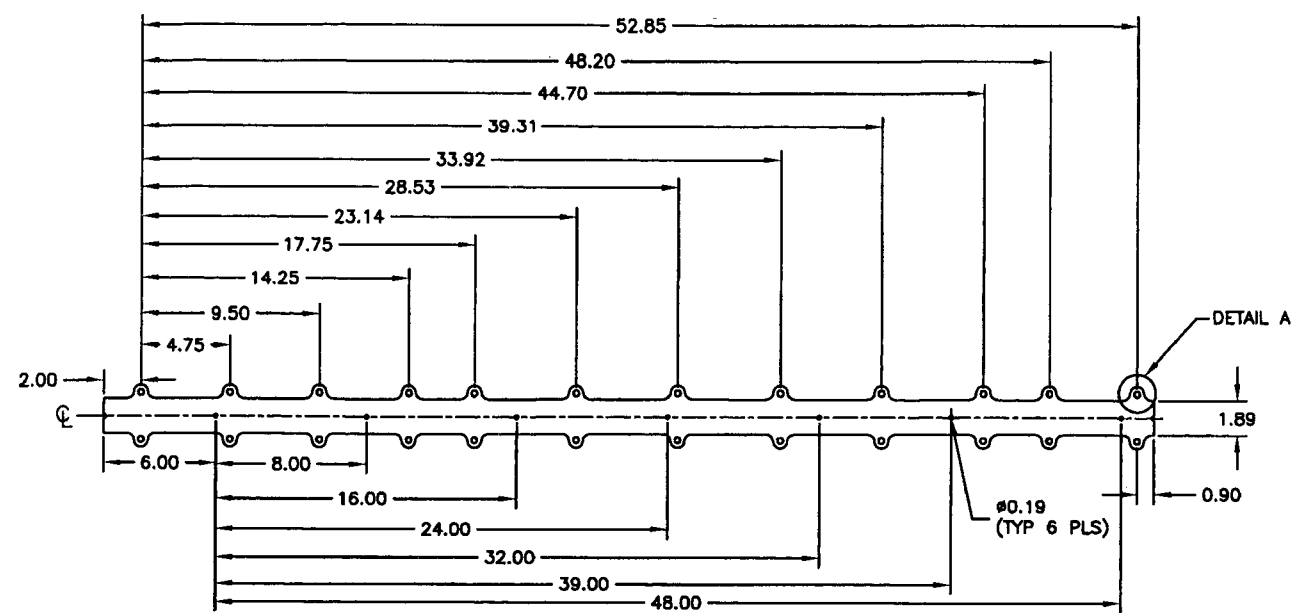
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

83391



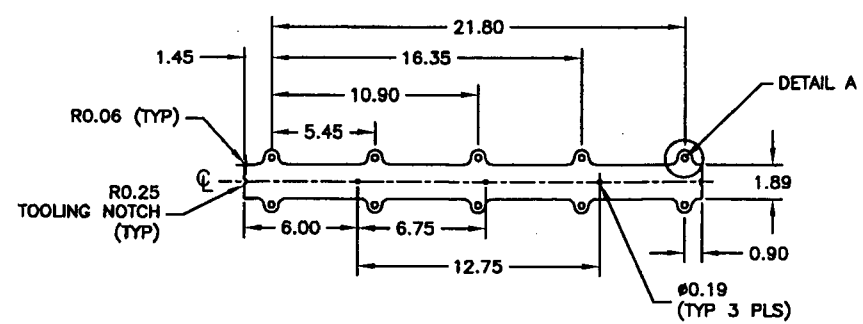
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	GASKET	REV. A
		DRAWING NO.	D3536	SHEET 3 OF 6
		SCALE	1:10	



**D3536-23 GASKET**

**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



**D3536-25 GASKET**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

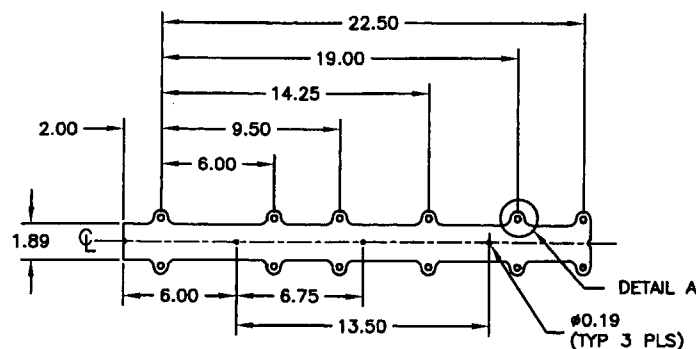
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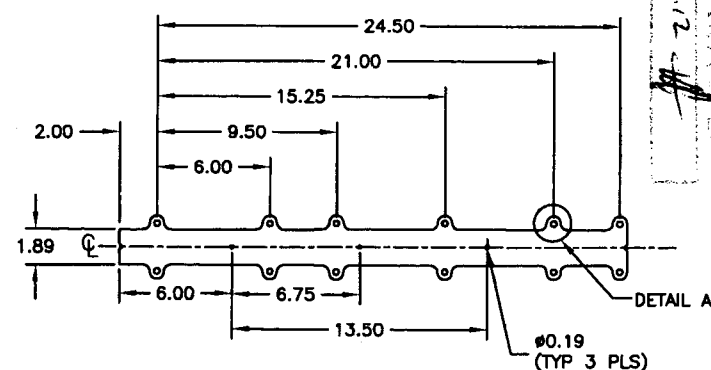
83391

**DART**

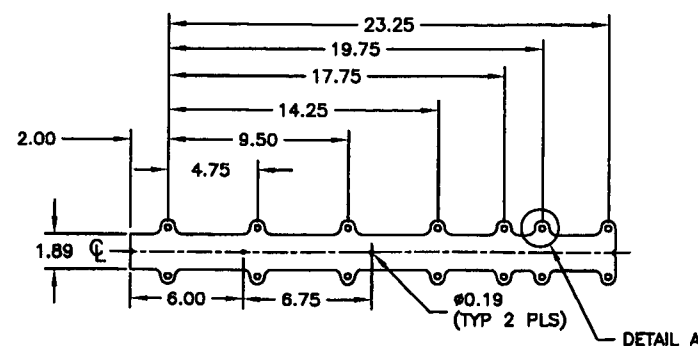
DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
			GASKET	SHEET 4 OF 6
		SCALE	1:10	



**D3536-31 GASKET**



**D3536-33 GASKET**



**D3536-35 GASKET**

**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
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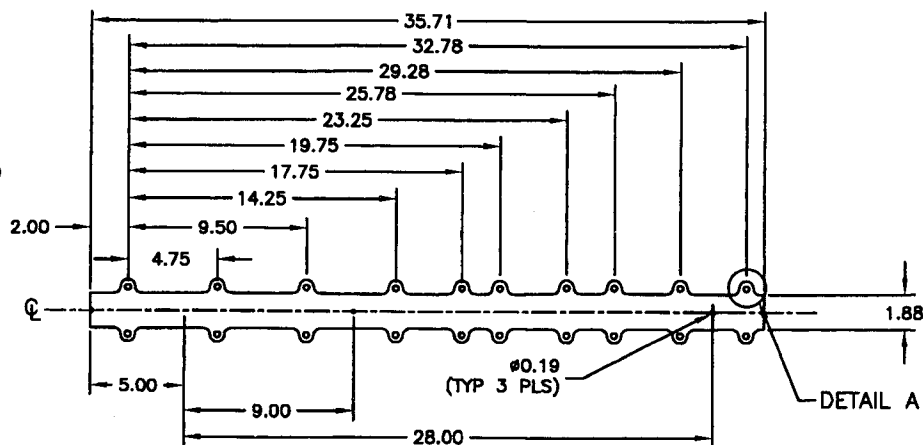
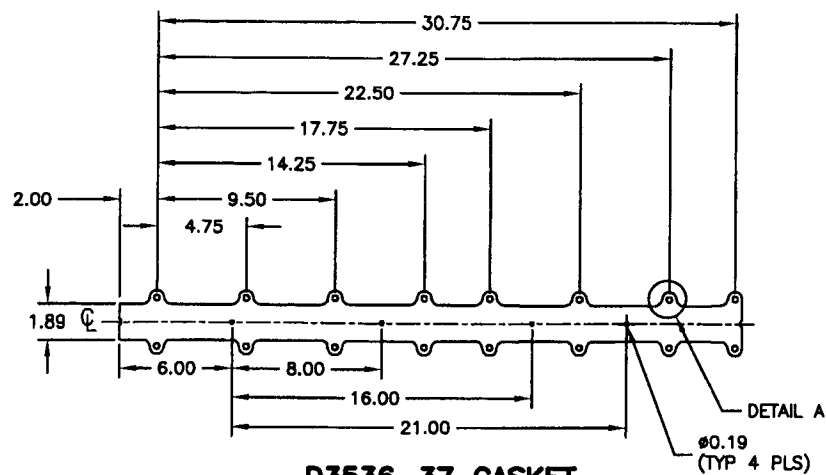
**NOTE:** Date & initial all entries



03391

**DART**

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	PH	APPROVED	PH	
DATE	06.10.25	TITLE	D3536	
			GASKET	REV. A
				SHEET 5 OF 6
				SCALE 1:10

**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
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# DART

070212 CH



- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
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